

Work Order ID 111510

111510

Page 1

January-15-14 1:17:00 PM

Item ID: D412-760-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protector

Start Date: 1/15/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DP *MC*

Date: 14-01-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-760

G

100

0.00

DAS

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-760-015 CHG002

14-2-5

1x *MC*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

17/2/3 *U* *DAS 32 9-89* *DAS 31 9-89*

120

QC4- 100% Inspect kits for completeness

0.00

DAS

120

QC

Memo

0.00

Quality Control

14-2-5

1x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 111510

January-15-14 1:17:00 PM

111510

Page 2

Item ID: D412-760-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protector

Start Date: 1/15/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-760-015								
	Location: <u>062</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(12) DAS 6 14-2-5 8
9-89

MCJ 14-02-05

MCJ 1402-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

January-15-14 1:16:59 PM

Page 1

Work Order ID: 111510
Parent Item: D412-760-015
Parent Item Name: Cabin Floor Protector

Start Date: 1/15/14
Start Qty: 1.00

Required Date: 1/15/14
Required Qty: 1.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-3 Cabin Floor Protector	DAS 6 9-89	Manufactured	No			110	Each	0.0000	112680	1	111572	31 9-89	DAS
D3574-6 Cabin Floor Protector	DAS 6 9-89	Manufactured	No			110	Each	0.0000	111504	1	111504	32 9-89	DAS
D3575-5 Cargo Floor Protector	DAS 6 9-89	Manufactured	No			110	Each	0.0000	111504	1	111504	32 9-89	DAS
D3575-6 Cargo Floor Protector	DAS 6 9-89	Manufactured	No			110	Each	0.0000	111537	1	111537	32 9-89	DAS
D3580-1 Joggle Bracket	DAS 6 9-89	Manufactured	No			110	Each	59.0000	6	6	32 9-89	31 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST055		59							
				104313		35							
				108217		24							
D3628-1 Cupped Washer		Manufactured	No			110	Each	346.0000	14	14	32 9-89	31 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		10							
				83587		10							
				ST057		336							
				96822		336							
D3628-3 Cupped Washer		Manufactured	No			110	Each	453.0000	6	6	32 9-89	31 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST057		453							
				96308		453							

DQA: _____ Date: _____



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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

January-15-14 1:16:59 PM

Page 2

Work Order ID: 111510
 Parent Item: D412-760-015
 Parent Item Name: Cabin Floor Protector

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 1.00

Required Qty: 1.00

MS24694-S100
 Flat Head Screw
 DAS
 6
 9-89

Purchased No

110 Each 157.0000



6 -

32
 9-89

Location

Loc Qty

Loc Code

ST304

157

125535

157

125535



MS24694-S54
 SCREW
 DAS
 6
 9-89

Purchased No

110 Each 336.0000



14

DAS

32

9-89

Location

Loc Qty

Loc Code

ST303

336

125535

336

m125535



NAS1149D0363J
 Washer

Purchased No

110 Each 3,352.0000



28

DAS

32

9-89

Location

Loc Qty

Loc Code

GA

78

124392

78

ST510a

3274

m126319

2074

m127813

1200

m126319



NAS1149D0463J
 WASHER

Purchased No

110 Each 7,533.0000



12

DAS

32

9-89

Location

Loc Qty

Loc Code

ST294

3133

M127693

3133

ST510a

4400

M127813

1400

M127904

3000

m127693

14/02/4 (1)



DAS
 6
 9-89

January-15-14 1:17:00 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART AEROSPACE LTD.

REFERENCE ONLY

DAS
6
9-80

IIN-D412-760
Page 41 of 43

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
1					D3574-1	CABIN FLOOR PROTECTOR
1					D3574-2	CABIN FLOOR PROTECTOR
	1				D3574-3	CABIN FLOOR PROTECTOR
	1				D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
1					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
	1				D3575-3	CABIN FLOOR PROTECTOR
	1				D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1149D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
6		6	6		MS24694S100	SCREW

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Revision: G
Date: 13.01.03